

# Work Order ID 83548

April-19-12 11:31:49 AM

**\*83548\***

Page 1

Item ID: D2739

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 350 I Beam

Start Date: 19/04/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: *ML5*

Date: *12/04/19*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.  
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739  
3-Use uni-bit to open holes to finish size as per Dwg D2739.  
4-Bevel Fwd end of extrusion and Deburr holes and ends.  
5-Deburr

*4* *CF* *12-4-23*

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

*(4)* *PK* *12-4-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83548

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**\*83548\***

Page 2

Item ID: D2739

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: 350 I Beam

Stop **\*NS2\***

Start Date: 19/04/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

*H D BE 12/04/23*

140

Identify as per dwg & Stock Location: LG

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

*DL 12/04/23*

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

*12/4/23*

*12-04-23*

W/O:		WORK ORDER CHANGES					
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# Picklist Print

April-19-12 11:31:53 AM

Page 1

Work Order ID: 83548

\*83548\*

Parent Item: D2739

\*D2739\*

Parent Item Name: 350 I Beam

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured

No

100

Each

152.0000

1

4

\*D2600-5-108\*

\*\*

④

CF 12-4-19

Extrusion 'I Beam' thin

## Location

## Loc Qty

## Loc Code

LG

152

47814

20

73909

132

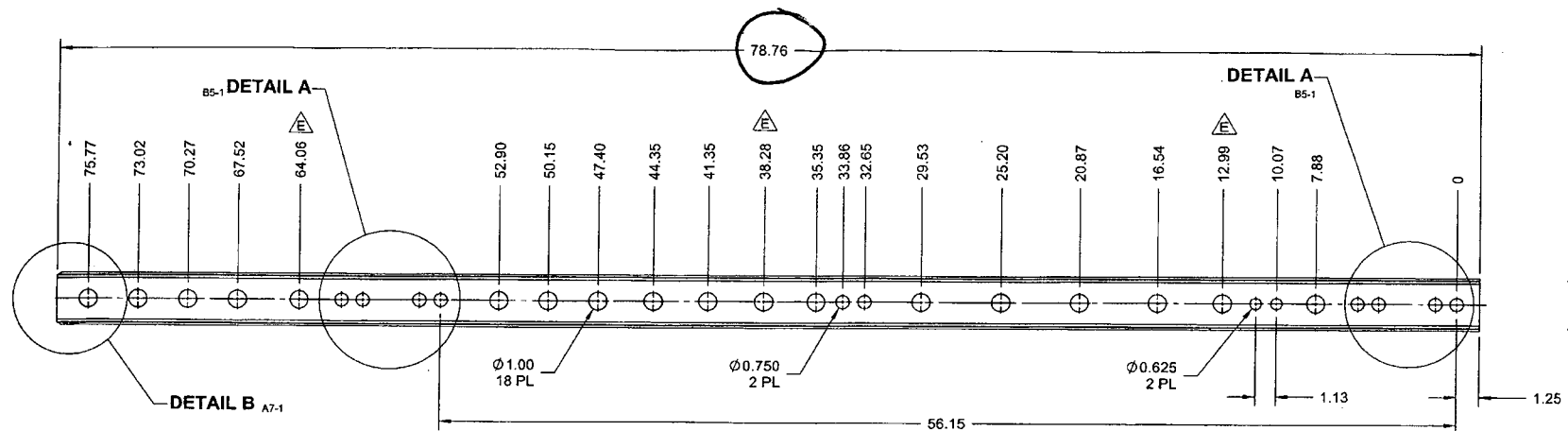
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

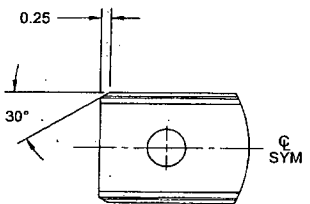
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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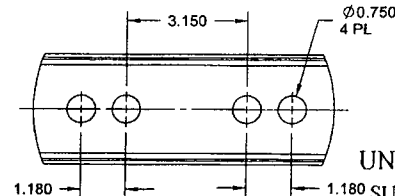
**NOTE:** Date & initial all entries



**D2739 WEB**



**DETAIL B**  
SCALE 3X C7-1



**DETAIL A**  
SCALE 3X D7-1, D2-1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 03548 MJS  
12/04/19

**RELEASED**  
2010-11-01

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
  - 7) WEIGHT: 3.41 lbs

E	ADD/MOVE HOLES FOR D4164 WEARPLATE: 38.28 WAS 38.35 (D3-1), 64.08 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	10.10.08		

<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWING NO. <b>D2739</b>	REV. E SHEET 1 OF 1
TITLE <b>WEB</b>	SCALE NTS

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